

Date: Wednesday, 2/15/2006 3:50:20 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	25861	Part Number	D2573		
Estimate Number	10533	Drawing Number	D2573 REV E		
P.O. Number	N/A	Project Number	N/A		
This Issue	2/15/2006	S.O. No.	N/A		
Prsht Rev.	NC	Drawing Revision	E		
First Issue	N/A	Material	N/A		
Previous Run	25832	Due Date	3/10/2006	Qty:	6 Um: Each
Written By	<u>See comment below</u>				
Checked & Approved By	<u>SK 06.02.16</u>				
Comment	Est: 1 As Per RevE 06-01-27 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>B24070 (4)</u> <u>B23941 (2)</u> <u>J.G 06/03/07 6</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>B25861</u> Double check by: <u>RG</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 <u>EJ</u> <u>J.G 06/03/01 6</u>	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>EJ</u> <u>J.G 06/03/11 6</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
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Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

BSG 06.03.13

6

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06.03.14

6

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 06.03.14

(6)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DL 06.03.14

(6)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST479

C 06.03.15

(6)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(6) 06.03.15

Job Completion



ur 06.03.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	25861
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.746	1.746	1.745	1.747		
C	3.495	3.505		3.498	3.496	3.494	3.498		
D	1.745	1.755		1.746	1.746	1.745	1.747		
E	7.990	8.010		8.005	8.004	8.004	8.006		
F	0.490	0.510		0.497	0.500	0.499	0.498		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.345	0.375	0.375		
I	0.490	0.510		0.498	0.501	0.502	0.502		
J	1.174	1.184		1.176	1.177	1.176	1.177		
K	0.558	0.578		0.564	0.564	0.567	0.566		
L	1.174	1.184		1.176	1.177	1.176	1.177		
M	1.365	1.375		1.367	1.368	1.368	1.368		
N	2.495	2.505		2.496	2.496	2.496	2.496		
O	4.119	4.129		4.121	4.121	4.121	4.121		
P	0.115	0.135		0.123	0.122	0.125	0.126		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.249	0.248	0.250	0.250		
S	0.115	0.135		0.126	0.126	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.231	0.236	0.234	0.236		
W	0.115	0.135		0.132	0.132	0.132	0.130		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.634	0.634	0.630	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.244	0.244	0.246		
AE	1.500	1.520		1.515	1.514	1.516	1.516		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.251	0.253	0.241		
AI	2.000	2.020		2.005	2.004	2.005	2.006		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by:	EP/5-G	Audited by:	BG
Date:	06/03/13	Date:	06-03-13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

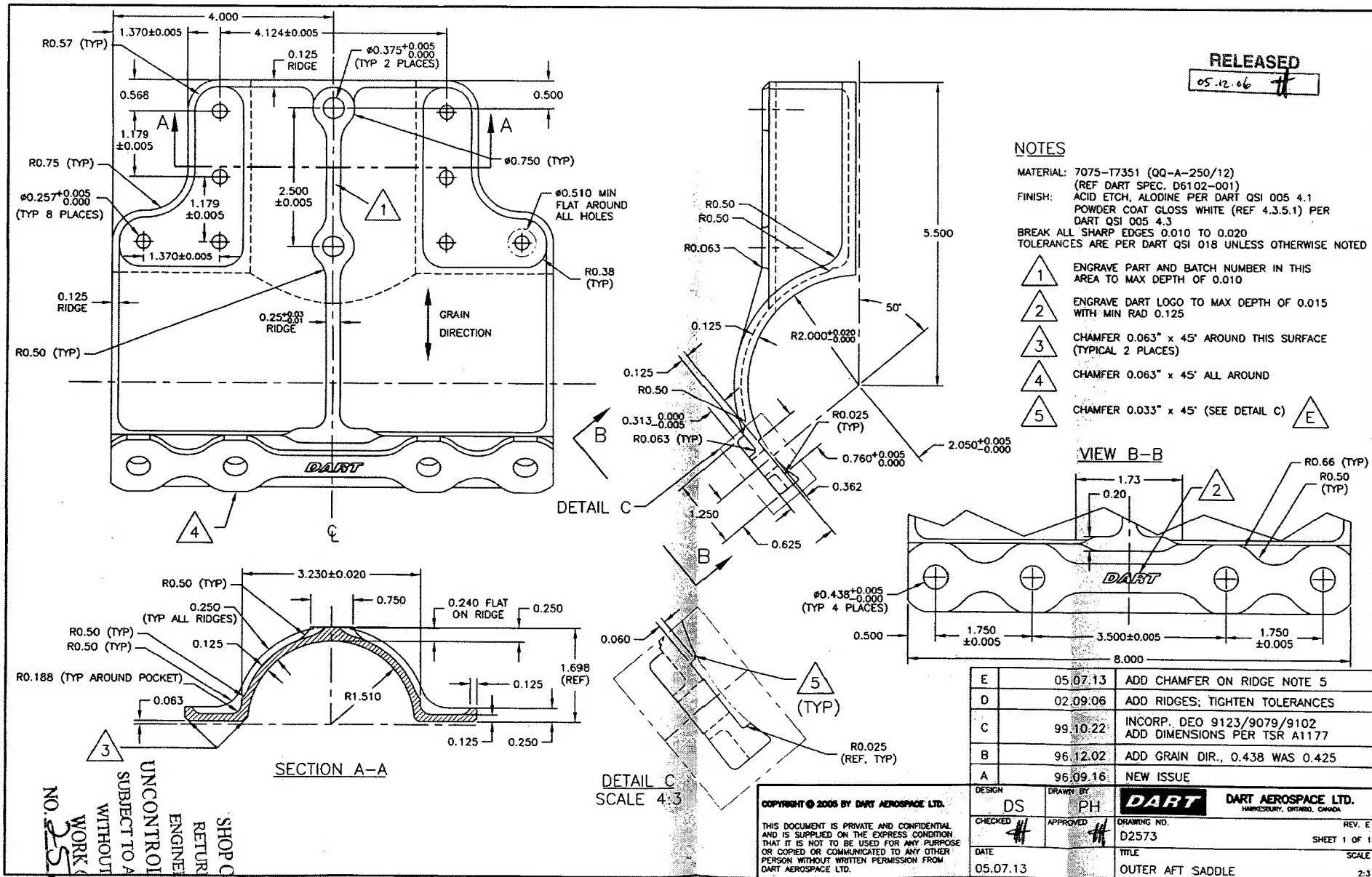
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N	2.495	2.505		2.496	2.496				
O	4.119	4.129		4.121	4.122				
P	0.115	0.135		0.121	0.125				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		0.246	0.245				
S	0.115	0.135		0.125	0.128				
T	0.178	0.198		0.188	0.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		0.235	0.235				
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